

Date: Wednesday, 10/31/2007 3:26:05 PM  
 User: Kim Johnston

## Process Sheet

|                                                        |                                         |
|--------------------------------------------------------|-----------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services         | Drawing Name : TUBE                     |
| Job Number : 35472                                     |                                         |
| Estimate Number : 11168                                |                                         |
| P.O. Number :                                          | Part Number : D22823                    |
| This Issue : 10/31/2007 S.O. No. :                     | Drawing Number : D2282 REV E            |
| Prsht Rev. : NC                                        | Project Number : N/A                    |
| First Issue : 1 / Type : MACHINED PARTS                | Drawing Revision : E                    |
| Previous Run : 33829                                   | Material :                              |
| Written By :                                           | Due Date : 11/30/2007 Qty: 100 Um: Each |
| Checked & Approved By : <i>[Signature]</i> 07.11.01    |                                         |
| Comment : Est Rev: A Removed from 9 Digit 05-12-02 JLM |                                         |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |                |                          |
|-----|----------------|--------------------------|
| 1.0 | M304TR0675W091 | 304 RD Tube .675 x .091W |
|-----|----------------|--------------------------|



Comment: Qty.: 0.2078 f(s)/Unit Total : 20.7795 f(s)  
 Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness  
 (M304TR0.675W.091) *51.5'*  
 Batch *17105223* *DSP 07/11/12* *20 07/11/13*

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2282 and Folio FA188

2-Deburr

*DSP 07/11/12* *20 07/11/13*

|     |     |                                        |
|-----|-----|----------------------------------------|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|----------------------------------------|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DSP 07/11/12* *20 07/11/13* *(251)*

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*8.5 07/11/14* *(251)* *(251)*

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*BARCLAY*
*Welding Francis / Steve*  
*07/11/14* *(251)*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:05 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 35472

Part Number: D22823

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



07.11.15

*[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u Still y*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

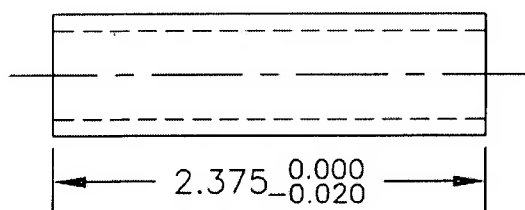
NOTE: Date & initial all entries



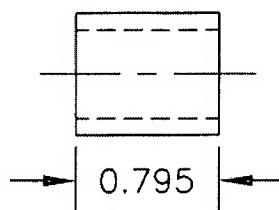


|                               |                                |                                                                 |                        |
|-------------------------------|--------------------------------|-----------------------------------------------------------------|------------------------|
| DESIGN<br>BW                  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA               |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282                                            | REV. E<br>SHEET 1 OF 2 |
| DATE<br>05.06.07              | TITLE<br>HANDLE TUBES          |                                                                 | SCALE<br>1:1           |
| A                             | 94.10.14                       | NEW ISSUE                                                       |                        |
| B                             | 95.03.23                       | RE-DESIGN                                                       |                        |
| C                             | 97.10.20                       | CORRECTED NUMBERING SCHEME                                      |                        |
| D                             | 05.03.16                       | REDESIGN D2282-5; 0.795 WAS 0.750                               |                        |
| E                             | 05.06.07                       | D2282-5 304 SS WAS 303 SS;<br>R0.063 x 0.063 WAS R0.080 x 0.030 |                        |

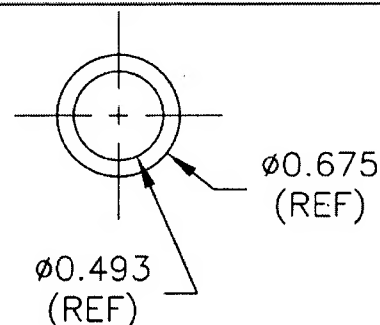
RELEASED  
*[Signature]*  
05/09/16



**D2282-3**

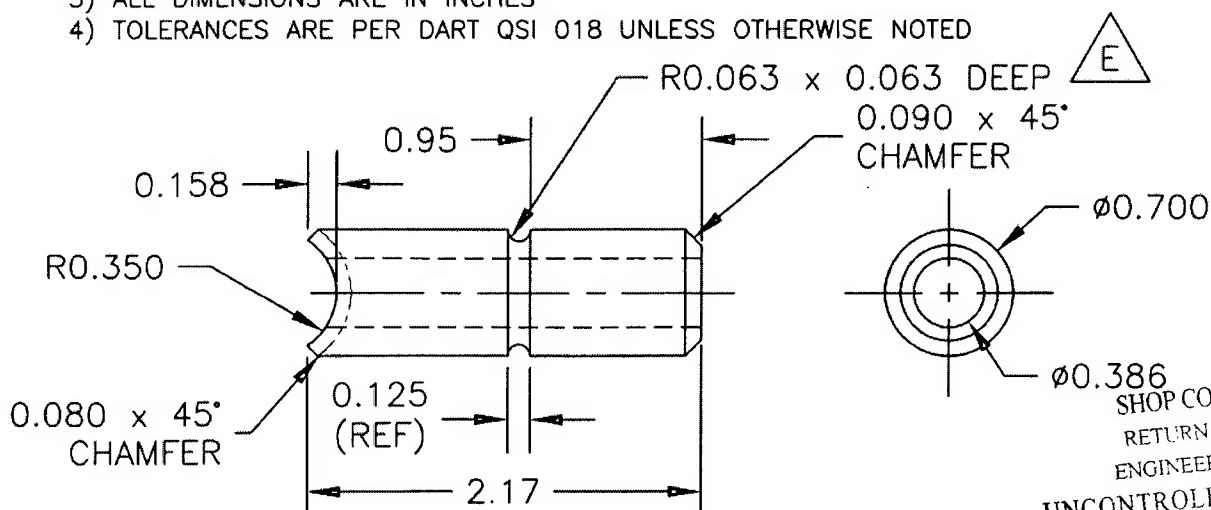


**D2282-7**



**D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**D2282-5**

**D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

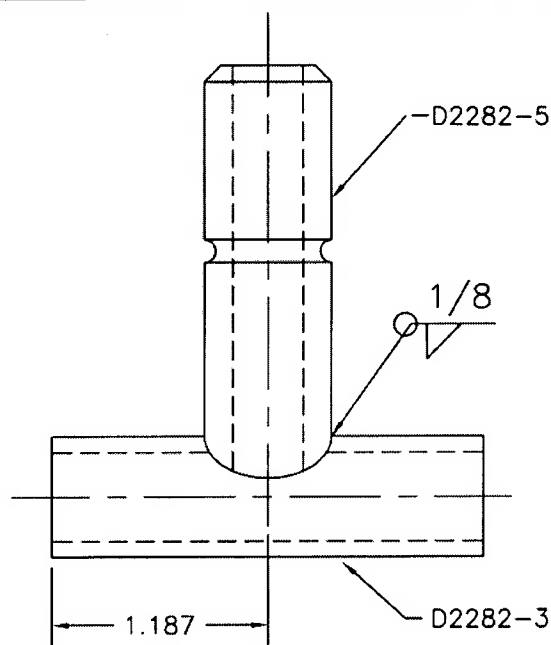
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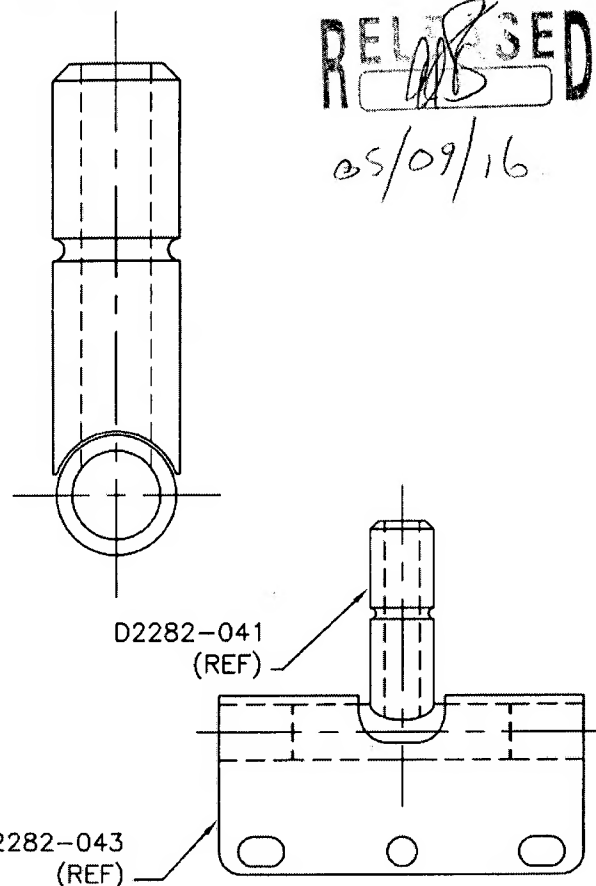
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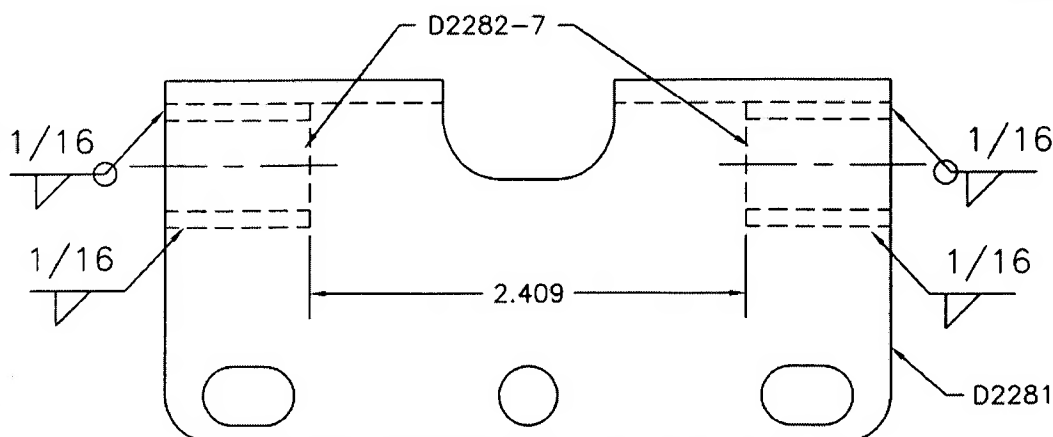
|                      |                                |                                                   |                        |
|----------------------|--------------------------------|---------------------------------------------------|------------------------|
| DESIGN<br>BW         | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>UP</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282                              | REV. E<br>SHEET 2 OF 2 |
| DATE<br>05.06.07     | TITLE<br>HANDLE TUBES          |                                                   | SCALE<br>1:1           |



**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004



**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

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